

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028325**Date Inspected:** 30-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** Jim Vanek**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K Soffit Opening**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, observed Quality Control Inspector (QCI), Jim Vanek, of American Bridge Manufacturing (ABM) monitored the welding of stainless steel Hinge K Soffit Openings, CCO 241. QCI was noted to monitor joint fit-up and welding amperage and voltage with an Amprobe Model ACDC-100. This QAI noted this instrument is within its calibration due date. QCI informed this QAI that welding was performed by a certified welder, Brian Moore, with amps at 210 and volt at 25. Welding was performed by Gas Metal Arc Welding (GMAW) using ER316-Si .045" diameter electrode in accordance to Welding Procedure Specification (WPS) # ABM-SAS-18, ABM-SAS-19, and ABM-SAS-20. QCI also informed this QAI that complete joint penetration (CJP) were ground to sound metal prior to finish welding with a back weld. This QAI randomly verified amperage, voltage, and joint fit-up. This QAI noted that Brian Moore stopped welding at 2 p.m. Ben Price, a welder of ABM, continued welding the Hinge K Soffit Openings. Fifteen Hinge K Soffit Openings frames were noted to be welded.

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	Hinge K Soffit Opening	ABM-SAS-18,19,20	Jim Vanek	210	25	14 ipm	n/a	Work still in progress

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Chang,Dan	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer